

Work Order ID 107832

October-03-13 11:37:12 AM

\*107832\*

Page 1

Item ID: D4074-1

Revision ID:

Item Name: Bracket

Start Date: 10/03/13 Start Qty: 16.00

Required Date: 10/11/13 Req'd Qty: 16.00

Reference:

Approvals: Process Plan: ✓ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

\*N900040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4074	C

100

\*100\*

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

0.00

0.00

24 0 Ae 13.10.05

110

QC2- Inspect parts off machine FAI/FAIB

\*110\*

QC

Quality Control

Memo

0.00

0.00

24 0 Ae 13.10.05

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Item ID: D4074-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Bracket

Start Date: 10/03/13 Start Qty: 16.00

\*16\*

Cust Item ID:

Required Date: 10/11/13 Req'd Qty: 16.00

\*16\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 DAS 27 9-89 0.00 B-10-7				24 can			
130 *130* Brake NC Brake NC	Bend as per dwg  Memo	0.00  0.00				24			83 13/10/02
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 DAS 27 9-89 0.00 B-10-7				24 can			

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Item ID: D4074-1      Accept      **\*N900040100\***      Setup Start **\*NS1\***  
Revision ID:      Stop **\*NS2\***  
Item Name: Bracket  
Start Date: 10/03/13      Start Qty: 16.00      **\*16\***      Cust Item ID:  
Required Date: 10/11/13      Req'd Qty: 16.00      **\*16\***      Customer:  
Reference:

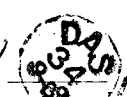
Approvals:      Process Plan:      Date:      Tooling:      Date:      Run Start **\*NR1\***  
QC:      Date:      SPC (Y/N):      Date:      Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*150*</b>									
HandFinish	Memo	0.00							
Hand Finishing									
160	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
<b>*160*</b>									
Powdercoat	Memo	0.00							
Powder Coating	POWDER COAT: 10-20 Start Time: 3200 Oven Temperature: 3200 Finish Time: 10-50								
170	QC3- Inspect Part Finish	0.00							
<b>*170*</b>									
QC	Memo	0.00							
Quality Control									

24 10/13/10/8

24 10/13/10/09

24 10/13/10/09



m126125

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Item ID: D4074-1

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Bracket

Start Date: 10/03/13

Start Qty: 16.00

**\*16\***

Cust Item ID:

Required Date: 10/11/13

Req'd Qty: 16.00

**\*16\***

Customer:

Reference:

Run Start

**\*NR1\***

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

**\*NR2\***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180

Identify as per dwg & Stock Location: ST091

0.00

**\*180\***

Packaging

Memo

0.00

Packaging

24

DAS  
33  
9-89

12-10-09

190

QC21- Final Inspection - Work Order Release

0.00

**\*190\***

QC

Memo

0.00

Quality Control

*[Signature]* / 12-10-10  
ME

12-10-09

# Picklist Print

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Page 1

Work Order ID: 107832

Parent Item: D4074-1

Parent Item Name: Bracket

Start Date: 10/03/13

Required Date: 10/11/13

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev:A 10.06.08 new issue DD verf:EC  
11-07-25 JLM VERIFIED BY:EC

IPP REV:B AS PER ECN 11-613

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125 6061-T6 .125 Sheet		Purchased	No			100	sf	120.4162	0.0452	1		13.10.05	

Location

Loc Qty

Loc Code

MAT021

120.4161578

121473

0.9161578

123279

72.89

125257

6.1

M126075

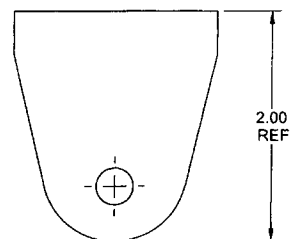
12.35

M126610

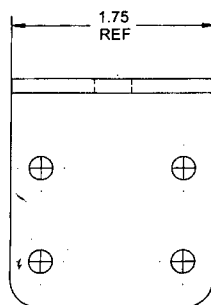
28.16

126610 → 1.5

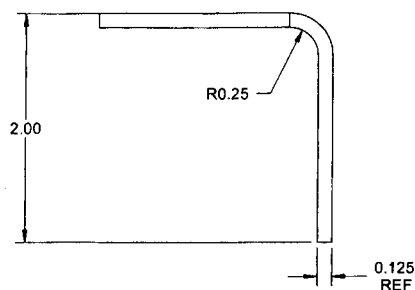




2.00  
REF

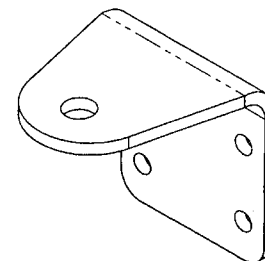


1.75  
REF



2.00

0.125  
REF



**D4074-1 BRACKET**  
(MAKE FROM D4074-1F FLAT PATTERN)

**NOTES:**

- 1) MATERIAL: MAKE FROM D4074-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.07 lbs

*w/6107832*

**RELEASED**  
2011-10-26  
*JH*

C	MODIFY -7 STRIKER PLATE, SHEET 6 AND 7	HS	11.10.12
B	Ø 0.173 WAS Ø 0.129 (ZN B3-4); 1.28 WAS 0.90 (ZN C4-6); 1.93 WAS 1.55 (ZN C2-7); 2.10 WAS 1.72 (ZN C1-7)	RF	11.03.07
A	NEW ISSUE	HS	10.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE USA, INC.</b> KENT, WA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>	DRAWING NO. <b>D4074</b> REV. C TITLE <b>BRACKET</b> SCALE NTS DATE <b>11.10.12</b>	

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